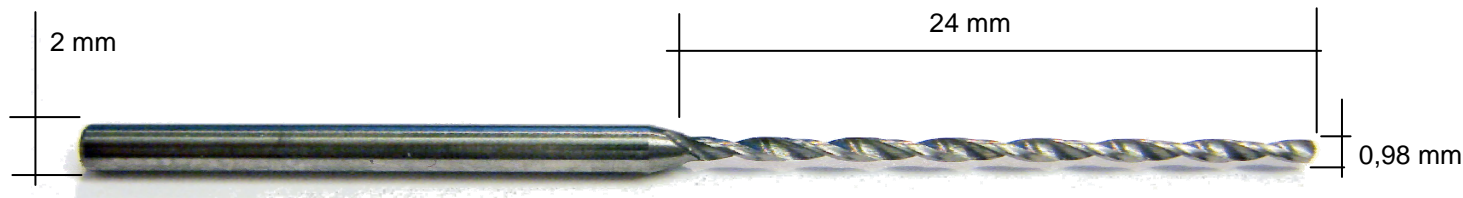


MicroDrill Ø0,98mm Z2

A05-010



1. Cycletime for Production

Tool specifications						
Diameter 0,98 mm, Z 2, Length of cutting edge 24 mm, Helix angle 30°						
Material CARBIDE						
Operations	Probe	Flute 1	Gashing	O.D.2	End 2	End 1
Feed [mm/Min]	2000	4000	90	4000	90	90
Power [kW]		1	2	1	1	1
Cutting feed [m/s]		18	32	24	24	24
Used wheels		15	8	8	4	4
Grinding time [s]	34	12	16	37	41	41
Total cycle time	3 Min 0					

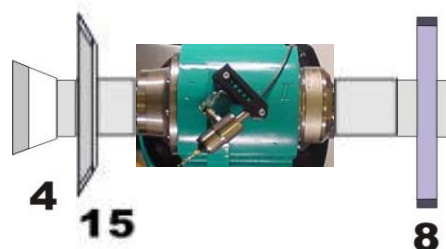
The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

15 Ø125 1V1 D46

8 Ø125 1A1 D46

4 Ø75 11V9 D46



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG
 Control: Fanuc 160i
 Coolant: Synthetic Oil, pressure 6 - 7 bar
 Software: Quinto 4.3, DXQ

responsible engineer:

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TECHNOLOGY
FOR TOOLING